

Date: Monday, 3/17/2008 11:56:54 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING ANGLE
Job Number	: 38026		
Estimate Number	: 10509		
P.O. Number	:	Part Number	: D2564
This Issue	: 3/17/2008 S.O. No. :	Drawing Number	: D2564 REV. B1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : MACHINED PARTS	Drawing Revision	: B1
Previous Run	: 36533	Material	:
Written By	:	Due Date	: 4/10/2008 Qty: 50 Um: Each
Checked & Approved By	: <u>080317</u>		
Comment	: Est:D 02.09.09 Re-format; Added FA276 Folio KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6207	Angle Extrusion 1x1x.125
-----	-------	--------------------------



Comment: Qty.: 0.0962 f(s)/Unit Total : 4.8090 f(s)
 Angle Extrusion
 Material: D6207 (1" x 1" x .125 angle) 6061-T6/T6511 (QQ-A-200/8)
 (D6207) Batch: B37670

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)

SA 08/03/27

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA276 Rev: A & Dwg D2564 Rev: B

2-Deburr if necessary

SA 08/03/27

(54)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/03/27

(54)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SA 08/03/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/17/2008 11:56:54 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING ANGLE

Job Number: 38026

Part Number: D2564

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

BigPAT

AS 08/03/28

(54)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/03

[Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-03-28

U

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

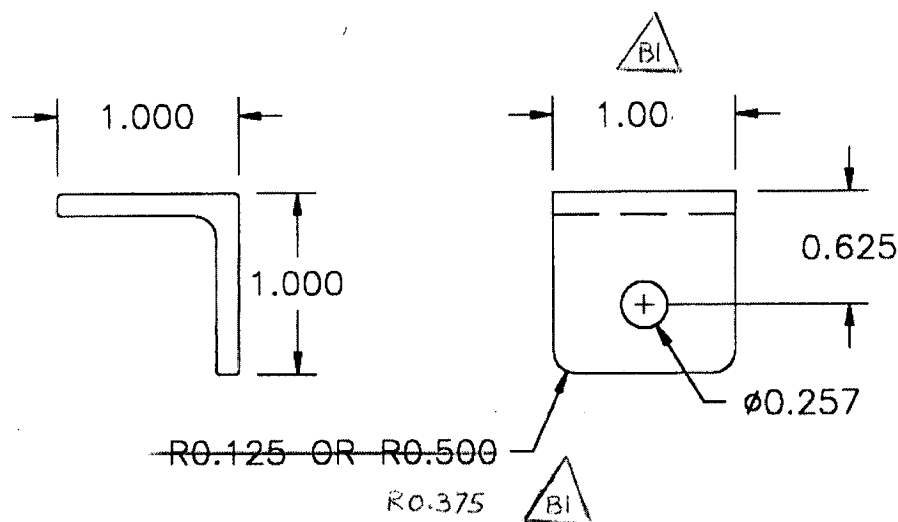
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	MIKE M	DRAWING NO.	REV. B
CHECKED	APPROVED	D2564	SHEET 1 OF 1
BW	BW		
DATE	TITLE		SCALE
96:04:30	MOUNTING ANGLE		1:1
B	97:05:06	MODIFIED DIMENSIONS	
BI	02.09.17	R0.375 WAS R0.125 OR R0.500; 1.00 WAS 1.000	

RELEASED
97/05/06 BW



NOTES:

- 1) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125
MAKE FROM D6207-XXX ANGLE EXTRUSION
- 2) BREAK ALL SHARP EDGES 0.005 - 0.015
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38026